



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2894-1
Job Sheet 173687



Part No: D2894-1

Job Qty: 10 ea → 9

Part Name: 2.75 Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP: B 02.11.26 Added mask hole KJ IPP Rev:C ECN 993 07-11-07 DD verified by:EC IPP D
08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER REV:C DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/13/18	0.00	0.00	Start Up Machining-1		KA 18-03-24
100	CNC Vertical Machining	10 pcs		4/16/18	0.79	24.63	HAAS1-2		KA 18-03-24
120	QC	10 pcs		4/16/18	0.00	0.00	QC8		AK 18/04/04
130	Packaging	10 pcs		4/16/18	0.00	0.00	Packaging3-1 LG051		AK APR 04 2018
140	QC21-SA	10 Ea		4/16/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FA253 Tumble & Deburr
Descriptions: 130 - LOCATION : LG051

DAS
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9-28

APR 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK079	D2894-1 Turning Detail	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK079	5	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
2	2.750 Support	3.062Inches + 0.020 - 0.000	3.082 3.062		
3	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
4	2.750 Support	1.766Inches + 0.020 - 0.000	1.786 1.766		
5	2.750 Support	0.020Inches + 0.020 - 0.000	0.040 0.020		
6	2.750 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
7	2.750 Support	0.170Inches + 0.020 - 0.000	0.190 0.170		

DQA:

Date: 180326



QA Closed:

DAS
53
9-89

Date:

MAY 25 2018

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 173687		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D2894-1		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No.		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 2018/03/26		Step #: 100		QTY Effective: 1				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				PD 18-3-26	
The measurement 1.776 ± 0.010 is under by 0.034				Scrap / no replace				Completed By Kt DAS 1 18-03-26 9-89	
-Try to rework and the piece was positioned wrong								Lead hand / Supervisor Approval Verification BA 18-03-26	
								QC / QA Coordinator Approval PD 18-3-26	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☒	Bending ☐	Set-up ☒	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

8	2.750 Support	0.150Inches	+ 0.020 - 0.000	0.170 0.150
9	2.750 Support	1.970Inches	+ 0.060 - 0.000	2.030 1.970
10	2.750 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240
11	2.750 Support	1.880Inches	+ 0.020 - 0.000	1.900 1.880
12	2.750 Support	0.500Inches	+ 0.005 - 0.000	0.505 0.500
13	2.750 Support	0.188Inches	+ 0.006 - 0.000	0.194 0.188

Plex 3/6/18 12:54 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S054586



Part: D2894-1

Job No: 173687

Serial No/Batch: S054586

Revision:

Inspector:

1470 Robinson Street
Hawkesbury, ON K6A 1K7
CANADA
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Date: 03/24/18

DART AEROSPACE LTD		Work Order:	173687
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894		Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		0.465	0.465	0.465	0.464	0.464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AD	1.766	1.786		1.777	1.778	1.778	1.778	1.776
AE	0.020	0.040		0.030	0.030	0.030	0.030	0.030
AF	0.260	0.267		0.261	0.261	0.261	0.261	0.261
AG	0.170	0.190		0.180	0.180	0.180	0.180	0.180
AH	0.150	0.170		0.160	0.160	0.160	0.160	0.160
AI	1.970	2.030		2.003	2.003	2.002	2.002	2.001
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	1.880	1.900		1.890	1.890	1.890	1.890	1.890
AL	0.500	0.505		0.500	0.500	0.500	0.500	0.500
AM	0.188	0.194		0.189	0.189	0.189	0.189	0.189
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by:	DAS 1	Date:	18-03-25
Audited by:	9-89	Date:	18/04/09
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	

DART AEROSPACE LTD		Work Order:	173687
Description: Ø2.750 Support		Part Number:	D2894-1
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FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	X6	X7	X8	X9	X10
HAAS Section								
AA	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AD	1.766	1.786		1.776	1.777	1.780	1.780	1.780
AE	0.020	0.040		0.030	0.030	0.030	0.030	0.030
AF	0.260	0.267		0.261	0.261	0.261	0.261	0.261
AG	0.170	0.190		0.180	0.180	0.180	0.180	0.180
AH	0.150	0.170		0.160	0.160	0.160	0.160	0.160
AI	1.970	2.030		2.001	2.005	2.003	2.002	2.002
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	1.880	1.900		1.890	1.890	1.890	1.890	1.890
AL	0.500	0.505		0.500	0.500	0.500	0.500	0.500
AM	0.188	0.194		0.189	0.189	0.189	0.189	0.189
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by:	Kt. 1 9-89	Date:	2018-03-28
Audited by:	gmk	Date:	18/04/04
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
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